

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009993**Date Inspected:** 28-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wuzhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (1AE-1BE)

This QA inspector checked excavated areas of weld joint -008 located on PCMK OBE1A Bottom panel of 1AE-1BE. Excavation was been performed against UT report attached along with Critical Welding Repair Report B-CWR874 Rev.0. The area excavated by ZPMC appeared to comply with the UT report.

OBG # TRIAL ASSEMBLY YARD (1AAE-1AE)

This QA inspector witnessed Magnetic particle Testing (MT) prior to welding of excavated locations of weld joint -003 located on PCMK OBE1A Bottom panel of 1AAE-1AE. Y locations of excavated areas was checked and appeared to comply with the UT report attached along with Critical welding report B-CWR8668 Rev.0.

OBG # TRIAL ASSEMBLY YARD (5CE)

Caltrans Quality Assurance (QA) inspector observed at the bottom and side Panel for skin flatness at 5CE segment located between PP34 to PP35. The surface flatness survey data was taken on the exterior side (Bike Path side).

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The out of flatness measurement is 10mm over a length of 630mm for bottom panel and 7mm over a length of 630mm for side panel.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check along with ABF on OBG skin plate flatness across transverse splice on below segments and readings found to be in general compliance.

5AW – 5BW

5BW – 5CW

5AE – 5BE

5BE – 5CE

OBG # TRIAL ASSEMBLY YARD

This QA inspector witnessed final tension verification for bottom panel of 2AW-2BW. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP-14, PP15 & PP16: M24 X 70 - Total bolts: 436

PP-14, PP15 & PP16: M24 X 85 - Total bolts: 15

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
